

Date: Tuesday, 10/02/2009 3:07:08 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROTECTOR RH
<b>Job Number</b> : 45706	
<b>Estimate Number</b> : 11225	
<b>P.O. Number</b> :	<b>Part Number</b> : D32803
<b>This Issue</b> : 10/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3280 REV.D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 39596	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 25/02/2009 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Julie Dawson 09.02.10</u>	
<b>Comment</b> : Est Rev:A 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL Est Rev C 08.03.11 Dwg. Rev Change. DL Est Rev D 08.04.15 Material Change DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET



**Comment:** Qty.: 4.3330 sf(s)/Unit Total : 21.6650 sf(s)  
 GE PLASTICS LEXAN SHEET

Material Batch Number

M106751 X1 M110877 X4

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 09/02/18 X5

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 012

Dwg. Rev.

Folio Rev.

BB 07/02/17 X5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

BB 09/02/19 X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:07:08 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR RH

Job Number: 45706

Part Number: D32803

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/02/24 X5

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 09/02/24 X5

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/24 X5

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pkg 5

JS 09/02/25 X5

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25 X5

Job Completion



U 09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45706
<b>Description:</b> R22 Floor Protector, RH		<b>Part Number:</b> D3280-3
<b>Inspection Dwg:</b> D3280	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

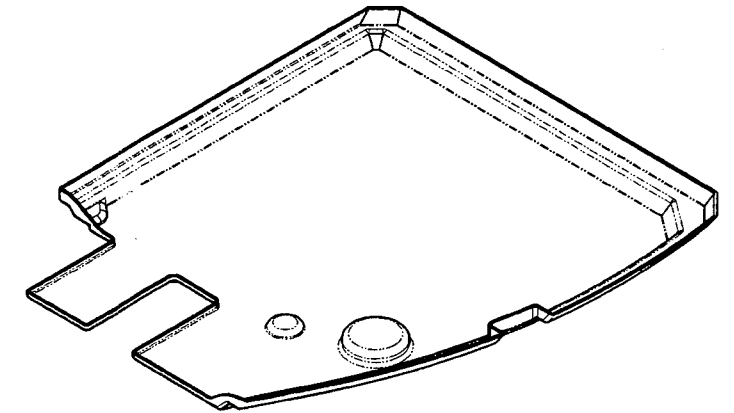
<b>Measured by:</b> [Signature]	<b>Date:</b> 09/02/24
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.3	✓			
15.8	+/-0.100	15.75	✓			
12.1	+/-0.100	12.1	✓			
0.95	+/-0.030	0.936	✓			
0.25	+/-0.030	0.247	✓			
0.070	Min	0.0705	✓			
0.050	Min	0.0575	✓			

<b>Measured by:</b> [Signature]	<b>Date:</b> 09/02/24
<b>Audited by:</b> [Signature]	<b>Date:</b> 09/02/24
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL [Signature]	[Signature]

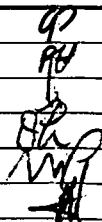


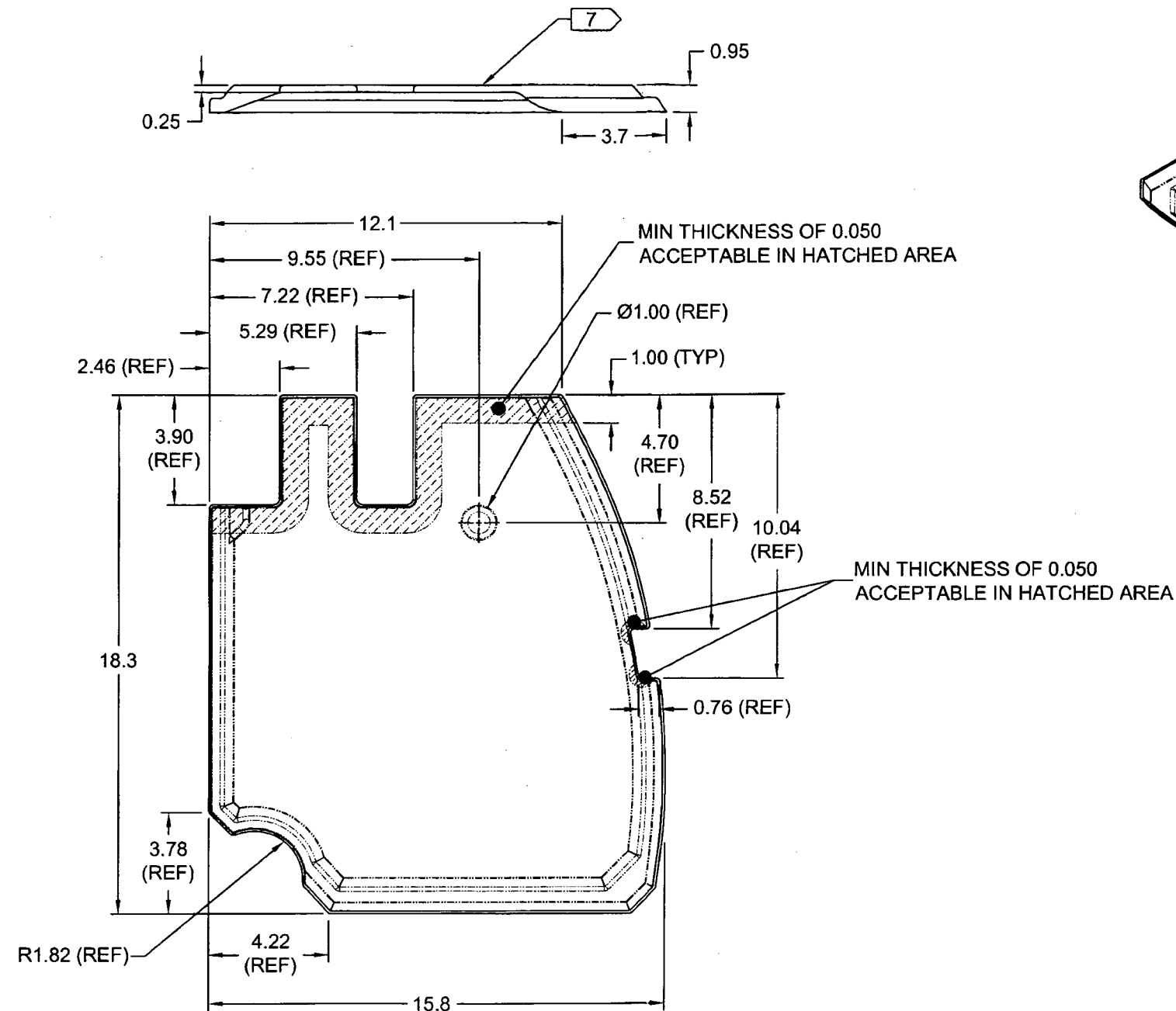
MIN THICKNESS OF 0.050  
ACCEPTABLE IN HATCHED AREAS

△ D

08-04-11

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ATTORNEY GENERAL  
T. J. ROE  
45706

D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3280	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	FLOOR PROTECTOR	NTS	
DATE	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
08.03.28			



**D3280-3 FLOOR PROTECTOR**

**D3280-3 NOTES:**

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.88 lb

DESIGN	92	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	R4		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	Shp	D3280	SHEET 2 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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